



Dart Aerospace Ltd.
1270 Aberdeen St
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20NR-86
Job Sheet 193795



Part No: 20NR-86

Job Qty: 5 pcs

Part Name: Dual Hook Cage Frame



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 5/10/19

Created By: Eric Larocque

Type: SOLD

Description:

Note: DWG 20NR-86 Rev.1 IPP Rev. A 19.02.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
110	Large Fab - Welded Assy-1	5 pcs	5/10/19	0.00	5.00	Large Fab - 1		
						Large Fab - 10		
						Large Fab - 2		
						Large Fab - 3		
						Large Fab - 4		
						Large Fab - 5		
						Large Fab - 6		
						Large Fab - 7		
						Large Fab - 8		
115	QC 9	5 pcs	5/10/19	0.00	0.00	QC 9 - 10		
						QC 9 - 18		
						QC 9 - 24		
						QC 9 - 43		
						QC 9 - 50		
						QC 9 - 9		
120	QC 5	5 pcs	5/10/19	0.00	0.00	QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		
QC 5 - 68								
QC 5 - 9								
QC 5 - 50								



DART
AEROSPACE

Container No: S177319



Part: 20NR-86
Job No: 193795
Serial No/Batch: S177319
Revision: 1
Inspector:
Exp Date:
Instructions:

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Date: 05/02/19

SCRAP



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Instructions:

Date: 05/02/19

				QC 5 - 30	
130	Powdercoat - 6 Fire Red - B4B	5 pcs	5/10/19	0.00 0.00	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
140	QC 3	5 pcs	5/10/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
180	Packaging 3-1 - Stock - B4B	5 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
190	QC 21 - SA	5 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 110 - 1-Weld as per DWG. Use 8/20NR jig to assemble. 3/8" welds on all parts. See note 1 and 2.

Descriptions: 115 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - Fire Red(Ref:4.3.5.10) per QSI005 4.3) Mask as per note 8. START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____

140 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

009532

Part / Item	Component Name	Quantity	Operation	Container
20NR-119-1	Bracket	10 pcs (2 ea)	110-Large Fab - Welded Assy-1	5168244
20NR-119-10	Support Tubing	10 pcs (2 ea)	110-Large Fab - Welded Assy-1	5173610
20NR-119-2-DHC	DHC Back Plate	5 pcs (1 ea)	110-Large Fab - Welded Assy-1	5168407
20NR-119-3P	Feeder Support Bracket	20 pcs (4 ea)	110-Large Fab - Welded Assy-1	5029429
20NR-119-4	Left Top Feeder	10 pcs (2 ea)	110-Large Fab - Welded Assy-1	5168401
20NR-119-4B	Bottom Left Feeder	10 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164329
20NR-119-5	Top Right Feeder	10 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164382
20NR-119-5B	Bottom Right Feeder	10 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164335
20NR-119-6	Upper Funnel Guide	20 pcs (4 ea)	110-Large Fab - Welded Assy-1	516821
20NR-119-7	Lower Funnel Guide	20 pcs (4 ea)	110-Large Fab - Welded Assy-1	5170080
20NR-119-8	Front Support	20 pcs (4 ea)	110-Large Fab - Welded Assy-1	5164256
20NR-119-9-DHC	Guard	5 pcs (1 ea)	110-Large Fab - Welded Assy-1	5173554
20NR-120-5	Funnel Tab	10 pcs (2 ea)	110-Large Fab - Welded Assy-1	5164391

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	20NR-119-1	10	15	0
	20NR-119-10	10	12	0
	20NR-119-2-DHC	5	6	0
	20NR-119-3P	20	13	0
	20NR-119-4	10	14	0
	20NR-119-4B	10	12	0
	20NR-119-5	10	14	0
	20NR-119-5B	10	12	0
	20NR-119-6	20	24	0
	20NR-119-7	20	24	0
	20NR-119-8	20	18	0
	20NR-119-9-DHC	5	6	0
	20NR-120-5	10	15	0

Part Specifications

Specifications could not be found.